

Wednesday, March 05, 2014 10:19:41 AM

Page 1

Stop ***NR2***

0.00

Quality Control

Work Order ID 114446

Wednesday, March 05, 2014 10:19:41 AM

114446

Page 2

Item ID: PB67-43001-01

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/21/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

PM 116584

APR 21 2014

06
9-89

14-4-23

MF
14-4-23

Picklist Print

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Wednesday, March 05, 2014 10:19:37 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
 IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP
 RevC 10.09.24 per RevC EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107		Purchased	No			100	Each	148.0000	8	16			
240-107									**			DAS 28 9-89	APR 02 2014
SPRING SLOTTED PIN													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST382		148							
				124060		14							
				M127995		134							
30345T22		Purchased	No			100	Each	24.0000	2	4			
30345T22									**			DAS 28 9-89	
8" LANYARD													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST379		24							
				m127014		4							
				m127979		20							
30345T24		Purchased	No			100	Each	57.0000	2	4			
30345T24									**			DAS 28 9-89	
LANYARDS													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		57							
				M127979		57							

Picklist Print

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Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

AN4-10A Purchased No 100 Each 95.0000 2 4

AN4-10A

Bolt

DAS
28
9-89

APR 02 2014

Location Loc Qty Loc Code

ST355 95
M127070 20
M127815 75

AN4-13A Purchased No 100 Each 928.0000 2 4

AN4-13A

Bolt

DAS
28
9-89

Location Loc Qty Loc Code

FG 20
122808 20
GA 14
m125709 14
ST515 894
m126193 12
m127432 36
m127817 846

AN4-15A Purchased No 100 Each 350.0000 4 8

AN4-15A

Bolt

DAS
28
9-89

Location Loc Qty Loc Code

GA 100
120449 100
st357 250
m127817 250

Picklist Print

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Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

AN6-11A Purchased No

100 Each 44.0000 2 4

AN6-11A

BOLT

DAS
28
9-89

APR 02 2014

Location

Loc Qty

Loc Code

ST339

44

114437

19

M127993

25

4X

AN6-20A Purchased No

100 Each 55.0000 2 4

~~***AN6-20A***~~

~~BOLT~~

~~******~~

~~DAS
28
9-89~~

Location

Loc Qty

Loc Code

ST340

55

M126105

25

M127044

30

4X

AN8-13A Purchased No

100 Each 43.0000 2 4

AN8-13A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST341

43

123482

18

M127993

25

4X

BSP43 Purchased No

100 Each 48.0000 4 8

RSP43

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

ST282

48

M127380

48

128636

Picklist Print

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114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

CR3213-4-05

Purchased

No

100

Each

296.0000

2

4

CR3213-4-05

RIVET

DAS

APR 02 2014

28

9-89

Location

Loc Qty

Loc Code

ST328

296

123301

190

m127376

106

4X

D3445-041

Manufactured

No

100

Each

9.0000

1

2

D3445-041

Belt Assembly

DAS

28

9-89

Location

Loc Qty

Loc Code

Mezz2

9

108356

9

2X

D3447-3

Manufactured

No

100

Each

19.0000

2

4

D3447-3

Square Spacer

DAS

28

9-89

Location

Loc Qty

Loc Code

Mezz2

19

103840

3

111111

16

4X

D3447-7

Manufactured

No

100

Each

7.0000

2

4

D3447-7

Clevis

DAS

28

9-89

Location

Loc Qty

Loc Code

Mezz2

7

109908

7

112980X1
3

Picklist Print

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Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

D3447-9 Manufactured No 100 Each 9.0000 2 4

D3447-9

Swing Arm

DAS
28
9-89

APR 02 2014

Location

Loc Qty

Loc Code

Mezz2

9

114033

110604

9

D3451-041 Manufactured No 100 Each 9.0000 1 2

D3451-041

Handle And Lock-Down Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz2

9

104490

1

111741

5

111742

3

2X

D3451-047 Manufactured No 100 Each 9.0000 1 2

D3451-047

Handle And Lock-Down Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz2

9

104630

1

111747

3

111748

5

2X

D3922-1 Manufactured No 100 Each 107.0000 2 4

D3922-1

Clip

DAS
28
9-89

Location

Loc Qty

Loc Code

ST072

107

111733

100

66852

7

4X

Picklist Print

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Wednesday, March 05, 2014 10:19:39 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

MS17984-C408

Purchased

No

100

Each

39.0000

2

4

MS17984-C408

PIN, QUICK RELEASE

APR 02 2014

DAS
28
9-89

Location

Loc Qty

Loc Code

ST332

39

m126872

9

m127376

10

m128051

20

~~1X~~
~~3X~~

MS17984-C418

Purchased

No

100

Each

44.0000

2

4

MS17984-C418

PIN, QUICK RELEASE

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

1

123482

1

ST332

43

m126872

2

m127255

1

m127993

40

4X

MS21042L3

Purchased

No

100

Each

3,569.000

2

4

MS21042L3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST314

2614

M127410

2573

M127831

41

ST506

955

123900

955

4X

Picklist Print

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Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

100

Each

5,807.000

8

16

MS21042I 4

Locknut

APR 02 2014

DAS
28
9-89

Location

Loc Qty

Loc Code

ST314

32

m126275

32

ST509

5764

m127255

816

m127813

1948

m128300

3000

ST518

11

m127376

11

16X

MS21042L6

Purchased

No

100

Each

217.0000

4

8

MS21042I 6

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST314

217

m127304

2

m127831

26

m127904

189

8X

MS27039-1-04

Purchased

No

100

Each

200.0000

2

4

MS27039-1-04

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST305

200

124555

190

m128228

10

4X

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Shop Packet Print

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Picklist Print

Wednesday, March 05, 2014 10:19:39 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-21

Purchased

No

100

Each

622.0000

2

4

MS27039-1-21

Screw

DAS

APR 03 2014

28

9-89

Location

Loc Qty

Loc Code

ST506

622

124326

122

m126319

100

m127904

400

4X

MS51859-6

Purchased

No

100

Each

113.0000

4

8

MS51859-6

WASHER

DAS

28

9-89

Location

Loc Qty

Loc Code

ST290

113

123482

63

m126474

50

8X

MS51859-7

Purchased

No

Each

111.0000

8

8

MS51859-7

Washer

DAS

28

9-89

Location

Loc Qty

Loc Code

ST290

111

123482

15

M127993

96

8X

MS51859-8

Purchased

No

100

Each

194.0000

8

16

MS51859-8

Washer

DAS

28

9-89

Location

Loc Qty

Loc Code

ST290

194

m127993

194

16X

Picklist Print

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Wednesday, March 05, 2014 10:19:39 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J Purchased No

100 Each 186.0000 6 12

NAS1149DN632J

DAS
28
9-89

APR 03 2014

Washer

Location

Loc Qty

Loc Code

ST293

186

128606

M126084

86

M127255

100

NAS1149F0316P Purchased No

100 Each 110.0000 4 8

NAS1149F0316P

DAS
28
9-89

WASHER

Location

Loc Qty

Loc Code

ST295

110

113237

10

113644

100

8X

NAS1149F0432P Purchased No

100 Each 814.0000 16 32

NAS1149F0432P

DAS
28
9-89

WASHER

Location

Loc Qty

Loc Code

ST295

750

128591

M127813

750

ST510a

64

M126221

64

NAS1149F0632P Purchased No

100 Each 233.0000 8 16

NAS1149F0632P

DAS
28
9-89

WASHER

Location

Loc Qty

Loc Code

ST295

233

18057

233

16X

Picklist Print

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Wednesday, March 05, 2014 10:19:40 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0832P

Purchased

No

100

Each

213.0000

2

4

NAS1149F0832P

WASHER

**

DAS
28
9-89

APR 03 2014

Location

Loc Qty

Loc Code

ST295

213

18057

213

4X

NAS43DD3-68

Purchased

No

100

Each

51.0000

2

4

NAS43DD3-68

Spacer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST275

51

124330

51

4X

PB67-43001-07

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-07

Fwd Blade Fold Assembly Weldment

**

3114050 → 2

DAS
24
9-89

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-11

Fwd Adjustable Blade Support Assembly

**

3113006 → 2

DAS
24
9-89

PB67-43001-15

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-15

Fwd Adjustable Blade Support Assembly

**

3113234 → 2

DAS
24
9-89

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-21

Upper Blade Support And Cover Assembly

**

3112988 → 2

DAS
24
9-89

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

2

PR67-43001-23

Lower Blade Support And Cover Assembly

**

3113402 → 2

DAS
24
9-89

Picklist Print

Wednesday, March 05, 2014 10:19:40 AM

Work Order ID: 114446

114446

Parent Item: PB67-43001-01

PR67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 3/5/2014

Required Date: 3/21/2014

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-261 Manufactured No

100 Each 34.0000 2 4

PR67-43001-261

Lever Arm

DAS
28
9-89

APR 03 2014

Location Loc Qty Loc Code

Mezz2

34

111102

16

113388

18

4X

PB67-43001-265 Manufactured No

100 Each 79.0000 4 8

PR67-43001-265

Deltin Bushing

DAS
28
9-89

Location Loc Qty Loc Code

Mezz2

79

111103

20

113389

40

99967

19

8X

PB67-43001-299 Manufactured No

100 Each 53.0000 2 4

PR67-43001-299

Bushing

DAS
28
9-89

Location Loc Qty Loc Code

Mezz2

53

113390

30

99957

23

4X

PB67-43001-45 Manufactured No

100 Each 0.0000 1 2

PR67-43001-45

Longitudinal Support

DAS
28
9-89

B113393 → 2

PB67-43001-51 Manufactured No

100 Each 0.0000 1 2

PR67-43001-51

Long T-Handle Assembly

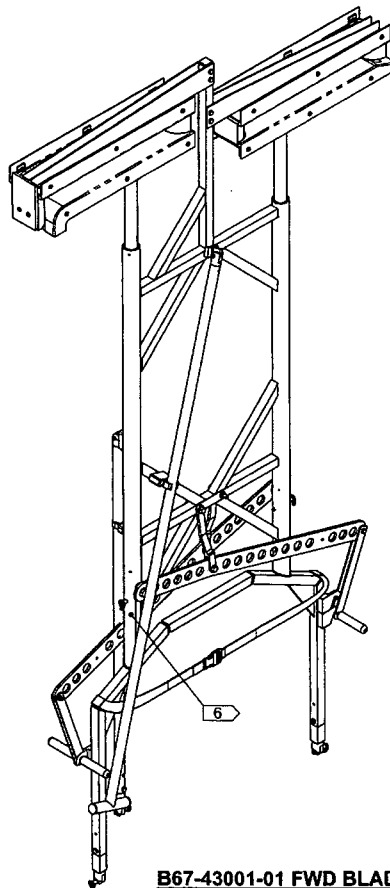
DAS
28
9-89

113392

ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELTRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-05	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\varnothing 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	VS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.06.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-01** REV. C
SHEET 1 OF 2
TITLE **FWD BLADE FOLD ASSY** SCALE NTS

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